

# Work Order ID 74052

Wednesday, September 21, 2011 9:04:00 AM

PRELIMINARY ISSUE

Page 1

Item ID: D3806-1

Accept

Revision ID:

Item Name: Bar

Start Date: 9/21/2011 Start Qty: 20.00

Required Date: 9/29/2011 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan: *N*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3806

*11.10.04*

*EC011-640*

100

0.00

Mill Conv

Memo

0.00

Conventional Milling Machine

1-mill as per Dwg D3806

2-Deburr if necessary

110

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: *W/H*

0.00

Packaging

Memo

0.00

Packaging



*D.A. 11/09/28*

*20*

*-inspector to PBI  
Dwg on ly  
8/11/09/29*

*counter  
(20)*

*KL 11-9-29*

*(20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74052

Wednesday, September 21, 2011 9:04:00 AM



Page 2

Item ID: D3806-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/4 78

mf  
11-09-29

POSITIVE RECALL  
EFFECTIVE 11/10/21 AUTH CR  
RELEASED ECN 11-640 DATE 11.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 21, 2011 9:03:57 AM

Page 1

Work Order ID: 74052

Parent Item: D3806-1

Parent Item Name: Bar



Start Date: 9/21/2011

Required Date: 9/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec  
 IPP Rev:B 08-09-23 redesign DD verified by:EC  
 IPP Rev:C 08-09-30 redesign DD verified by:EC  
 D 11.06.03 re-design EC verified by:DD IPP rev

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 		Purchased	No			100	f	205.3147	3.66	77.05263			
304 BAR .250 x .500													

Location

Loc Qty

Loc Code

MAT006

109.3

116148

78

117842

31.3

MAT050

96.0147

117176

96.0147

→ M 119050

104.00<sup>ft</sup>

D.A 11/09/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

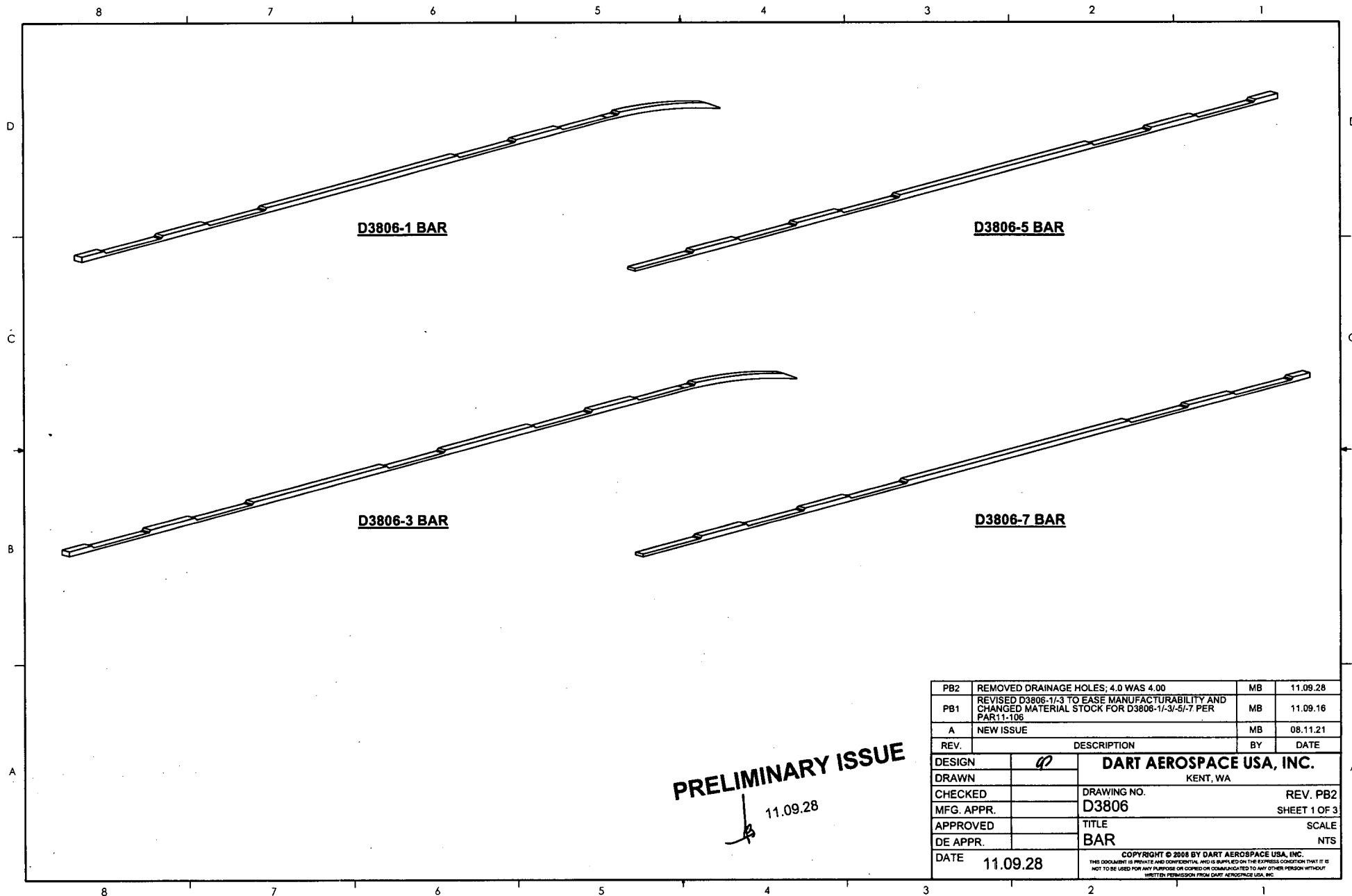
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

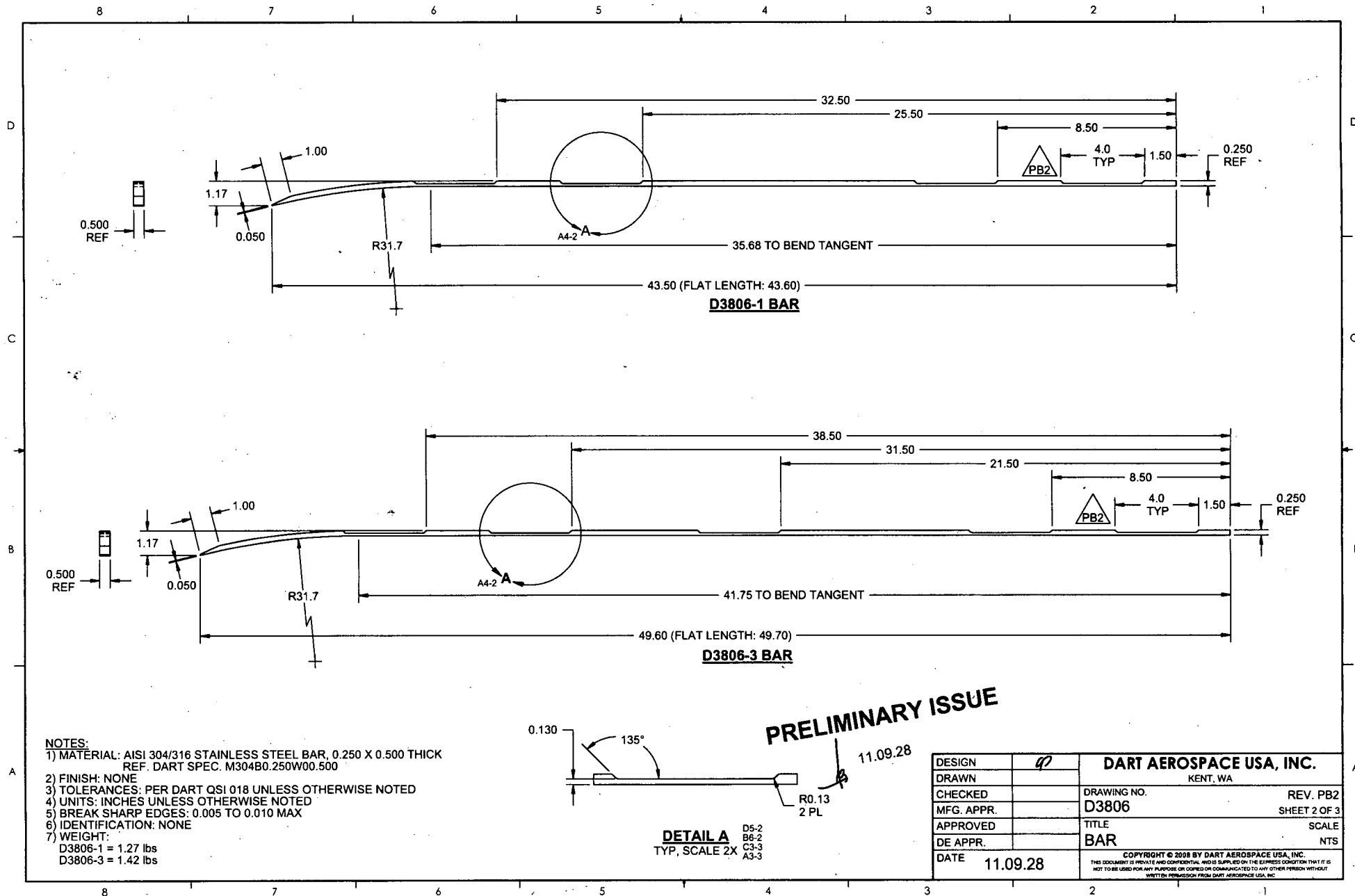








PB2	REMOVED DRAINAGE HOLES; 4.0 WAS 4.00	MB	11.09.28
PB1	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY AND CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PAR11-106	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	42	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		<b>D3806</b>	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BAR</b>	NTS
DATE	11.09.28	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



NOTES:

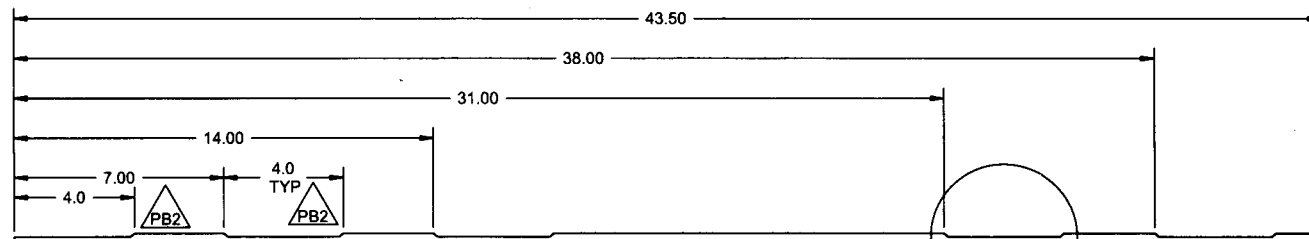
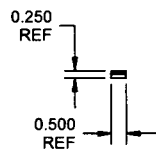
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK  
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:  
D3806-1 = 1.27 lbs  
D3806-3 = 1.42 lbs

PRELIMINARY ISSUE

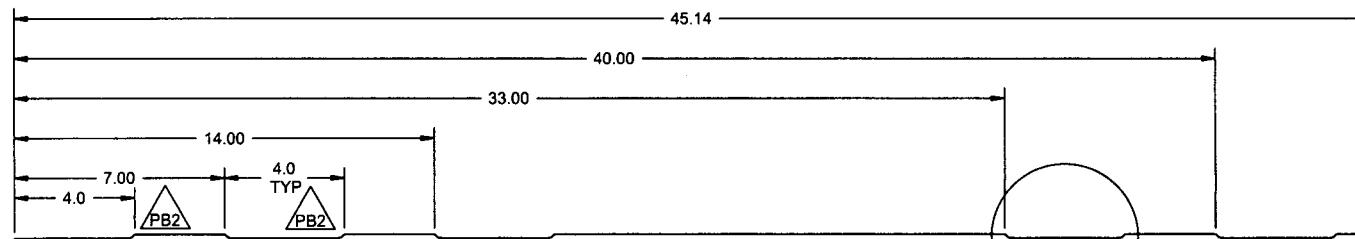
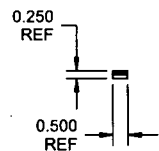
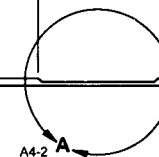
DETAIL A  
TYP, SCALE 2X

D5-2  
B6-2  
C3-3  
A3-3

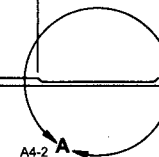
DESIGN	47	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. PB
MFG. APPR.		D3806	SHEET 2 OF 3
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DE APPR.		BAR	NTS
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**D3806-5 BAR**



**D3806-7 BAR**



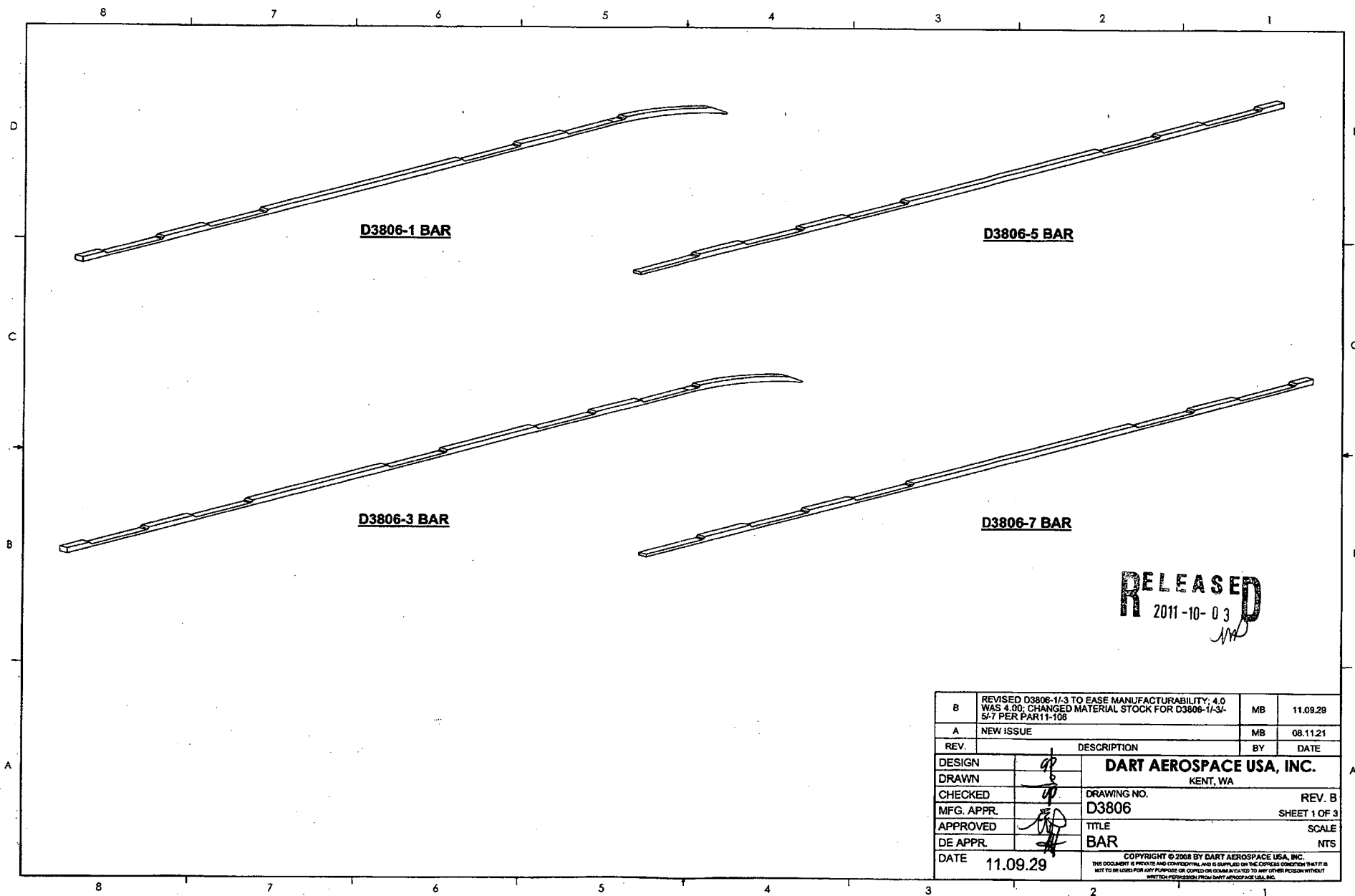
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REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:  
D3806-5 = 1.22 lbs  
D3806-7 = 1.28 lbs

**PRELIMINARY ISSUE**

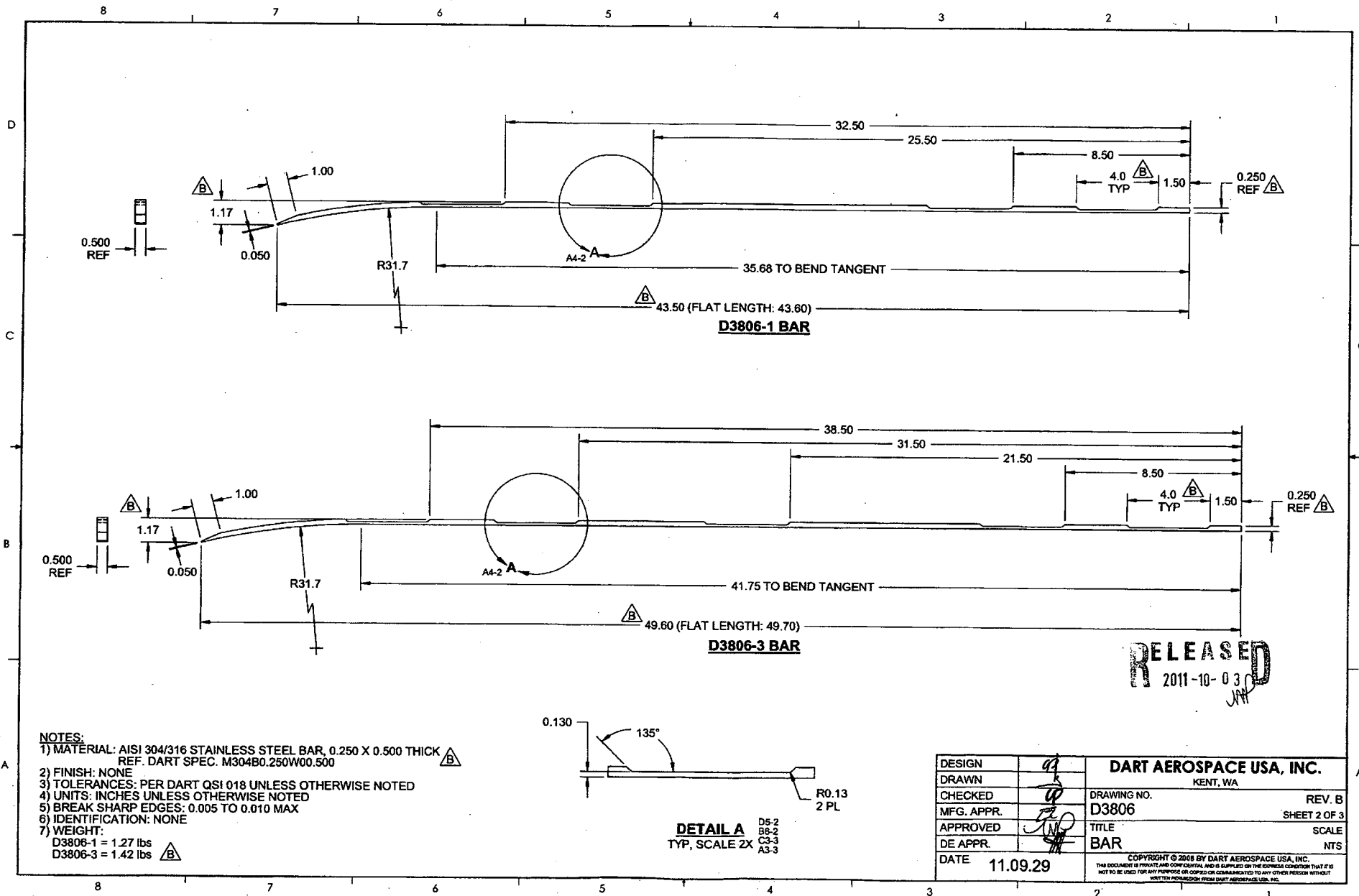
11.09.28

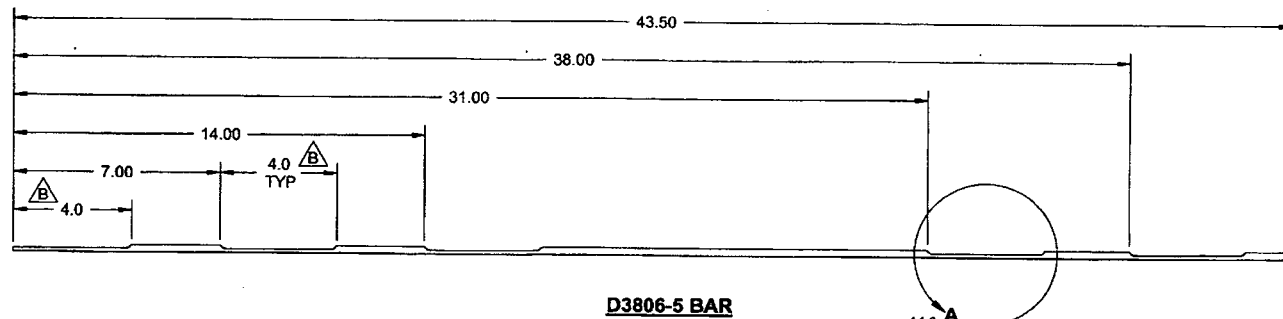
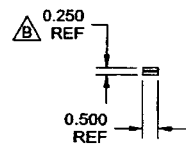
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		<b>D3806</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BAR</b>	NTS
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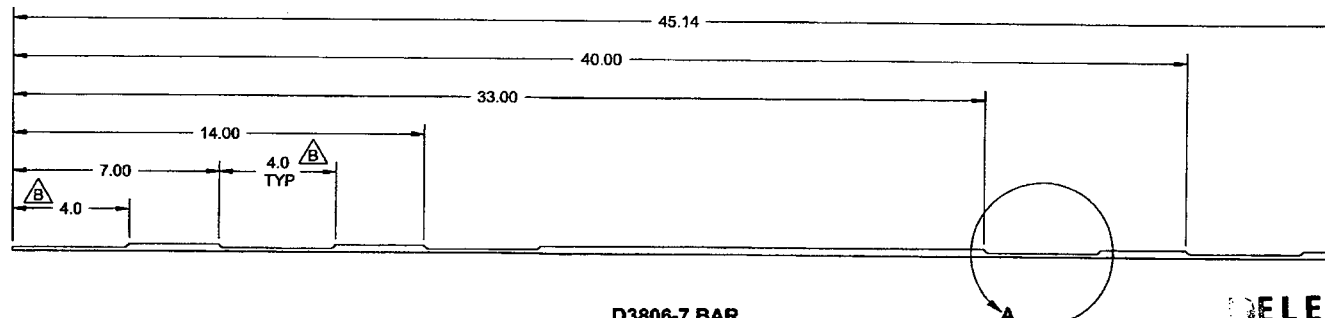
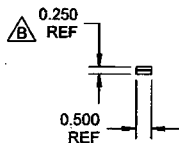
**RELEASED**  
2011-10-03  
*MM*

B	REVISED D3806-1/3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PAR11-108		MB	11.09.29
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC.			
DRAWN	KENT, WA			
CHECKED	DRAWING NO. D3806		REV. B	
MFG. APPR.			SHEET 1 OF 3	
APPROVED	TITLE BAR		SCALE	
DE APPR.			NTS	
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**D3806-5 BAR**



**D3806-7 BAR**

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D3806-5 = 1.22 lbs  
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**RELEASED**  
2011-10-03

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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